



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D206-642-541
Job Sheet 200929



Part No: D206-642-541

Job Qty: 1 pcs

Part Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/19/19

Job Tracking No:

Due Date: 10/18/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG D3274-041 REV G IPP Rev:F 08-06-02 add comment DD verified by:EC IPP Rev:G 08-10-09 revise details DD verified by:EC IPP REV:H 13.09.05 CHG004/ ECN13-634 DD VERF:JLM IPP REV:I 14.04.28 AS PER ECN14-520 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	10/18/19		0.00	2.17	Skidtubes - 1		TF DE
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
114	QC 5	1 pcs	10/18/19		0.00	0.00	QC 5 - 10		DAS 24 9-89 SEP 25 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
116	QC 10	1 pcs	10/18/19		0.00	0.00	QC 5 - 50		DAS 24 9-89 SEP 25 2019
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		



Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
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Container No: S216426



Part: D206-642-541

Job No: 200929

Serial No/Batch: S216426

Revision: G

Inspector:

Exp Date:

Instructions: FAA STC SA00475SE 18/10/17, TC STC SH98-

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120 Handfinish - 1-1 Chemical-B4B	1 pcs	10/18/19	0.00 0.68	QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				Handfinish - 1 - 1 - B4B	BEB 19-10-02.
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
130 QC 7	1 pcs	10/18/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				Plex 9/19/19 10:47 AM Dart.lajeunesse.marie	

					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	MGO-TF
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
150 Skidtubes - 2 - B4B	1	10/18/19	0.00 2.08	pcs	Skidtubes - 1 - B4B	
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	TF
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
160 QC 5	1	10/18/19	0.00 0.00	pcs	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	BE/ MGO
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
170 Skidtubes - 3 - B4B	1	10/18/19	0.00 2.17	pcs	Skidtubes - 1 - B4B	BE MGO
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	MGO MGO
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
180 QC 5	1	10/18/19	0.00 0.00	pcs	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	BE
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	

				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
190 Skidtubes - 4 - B4B	1 pcs	10/18/19	0.00 2.75	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
			24230	Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
200 QC 5	1 pcs	10/18/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	DAS
				QC 5 - 68	OCT 31 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
210 QC 10	1 pcs	10/18/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
220 Handfinish - 2-1 Pressure-B4B	1 pcs	10/18/19	0.00 0.45	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	OCT 31 2019
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
230 Spray Paint - 2 - B4B	1 pcs	10/18/19	0.00 0.40	Spray Paint - 1 - B4B	DAS
				Spray Paint - 2 - B4B	41 NOV 02 2019
				Spray Paint - 3 - B4B	9-89
				Spray Paint - 4 - B4B	
240 QC 14	1 pcs	10/18/19	0.00 0.00	QC 14 - 15	M 19-11-05
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	

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						QC 14 - 9	
						QC 14 - 68	
						QC 14 - 40	
						QC 14 - 19	
						QC 14 - 43	
						QC 14 - 24	
						QC 14 - 61	
						QC 14 - 81	
244	Handfinish - 3-1- WingWalk- B4B	1 pcs	10/18/19	0.00	0.50	Handfinish - 3 - 1 - B4B	ML 14-11-05
						Handfinish - 3 - 2 - B4B	
						Handfinish - 3 - 3 - B4B	
						Handfinish - 3 - 4 - B4B	
						Handfinish - 3 - 5 - B4B	
246	QC 3	1 pcs	10/18/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	BEB 19-11-05
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
250	Handfinish - 4-1-Assembly- B4B	1 pcs	10/18/19	0.00	0.45	Handfinish - 4 - 1 - B4B	ML 14-11-05
						Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 -	
						Plex 9/19/19 10:47 AM Dart.lajeunesse.marie	

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DAS
59
9.89

260 QC 5	1 pcs	10/18/19	0.00 0.00	B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	DAS
				QC 5 - 22	81
				QC 5 - 24	9-89
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
270 Handfinish - 4-2-Assembly- B4B	1 pcs	10/18/19	0.00 0.68	Handfinish - 4 - 1 - B4B	14-11-04
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
280 QC 5	1 pcs	10/18/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	

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					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS NOV 06 2019 68
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
290	Packaging 3-1 - Stock - B4B	1	10/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
295	DC - 1 - B4B	1	10/18/19	0.00 0.00	DC - 1 - B4B	DAS NOV 07 2019
	pcs				DC - 2 - B4B	21
300	QC 21 - FG	1	10/18/19	0.00 0.00	QC 21 - FG - 21	9-89
	pcs				QC 21 - FG - 70	DAS NOV 07 2019
					QC 21 - FG - 53	21

Part Op 110 - (Skidtubes) ****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE**** 1- remove fwd indexing ridge as per Descriptions: dwg D3274. Prepare for welding 2- weld fwd cap as per dwg D3274 and QSI004 AR Aluminum Rod Batch: 138989/139011 3- grind fwd cap weld on top surface only 4- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end. 5- Drill Aft cap pilot hole using DT8025 6 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D and DT8742. Drill 3/16" pilot holes as per Dwg D3274 7 -Remove inner indexing ridge on aft end of

Skid tubes
5200625
07,25,20

skidtube as per Dwg D3274 scribe batch # 8 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

114 - (QC5- Inspect part completeness to step on W/O)

116 - (QC10- Inspect visual per QSI004- ground welds)

120 - (Chemical Conversion Coat per QSI005 4.1)

130 - (QC7-Inspect Chemical Conversion Coat)

150 - (Skid tubes) 1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274 2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube 3-Bond web in place as per Dwg D3274 & QSI 015. (Adhere for 12 hours)

160 - (QC5- Inspect part completeness to step on W/O)

170 - (Skid tubes) 1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position. 2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Deburr 3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES 4- Countersink crossbolt spacer holes as per Dwg D3274 5- prepare for welding

180 - (QC5- Inspect part completeness to step on W/O)

190 - (Skid tubes) 1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod 3-Grind cross bolt welds flush as per Dwg D3274.

****INSPECT FOR PIN HOLES IN WELD**** 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

200 - (QC5- Inspect part completeness to step on W/O)

210 - (QC10- Inspect visual per QSI004- ground welds)

220 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

230 - (Spray Paint / NDT Room) Make sure Nut Plate Thread is protected using paint screw,. 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5200399 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5213125

240 - (QC14- Inspect Spray Paint)

244 - (Wing Walk as per dwg QSI005 4.4 Batch 5209362

246 - (QC3- Inspect Part Finish)

250 - (Assemble as per dwg) 1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.

260 - (QC5- Inspect part completeness to step on W/O) Inspect Nut Plate & Inserts

270 - (Assemble as per dwg) 1-Install wearpads as per Dwg D3274. 2-Install ring as per Dwg D3274 3-Inspect for foreign objects as per QSI 024 4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

280 - (QC5- Inspect part completeness to step on W/O)

290 - (Identify as per dwg & Stock Location: _____) Location : FG073

295 - (Document Control) Photocopy bluefile & type labels per PPP D206-642- 541 CHG005

300 - (QC21- Final Inspection - Work Order Release) 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 using DT10280 and deburr.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3274-041BENT	Skidtube Assembly 206	1 pcs (1 ea)	110-Skidtubes - 1	012768
D3285-1	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5189763
D3282-041	Float Web (206L/407)	1 pcs (1 ea)	150-Skidtubes - 2 - B4B	5043738
D2649	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	5191355
D3275-1	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	5214170
ALS4-1032-130	Rivnut	78 Ea (78 ea)	250-Handfinish - 4-1-Assembly-B4B	5199330
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5057257
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5044573
D3415-041	Nut Plate	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5163230-7
AN3C4A	Bolt <u>5225314 G1A</u>	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	5218586
AN4C5A	Bolt	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5228822 (v3)
D2646	Aft Cap	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5057441
D3413-1	O-Ring	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5197616
D3537-1	Wearpad <u>5207774 (v1)</u>	9 pcs (9 ea)	270-Handfinish - 4-2-Assembly-B4B	F165886
D3537-3	Wearpad	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	* 5225794 (v1)
D3672-1	Washer, Phenolic	2 pcs (2 ea)	270-Handfinish - 4-2-Assembly-B4B	5218987
D4956-15	Wearplate Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	F164008
D4956-23	Wearplate Center Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5200829
D4956-35	Wearplate Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	520726
D4956-39	Wearplate Center Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5204483
NAS1149C0332R	Washer (AN960C10L)	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	5201005
NAS1149C0463R	Washer (AN960C416)	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5218121
				5104377

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D3274-041BENT	1	5	0
	D3285-1	1	7	0
150-Skidtubes - 2 - B4B	D3282-041	1	3	0
190-Skidtubes - 4 - B4B	D2649	12	83	0
	D3275-1	12	196	0
	ALS4-1032-130	78	5,946	0
250-Handfinish - 4-1-Assembly-B4B	CCR264SS3-3	2	55	0
	CR3212-4-03	2	38	0
	D3415-041	1	1	0
	AN3C4A	80	584	0
	AN4C5A	1	70	0
	D2646	1	58	0
	D3413-1	1	19	0
	D3537-1	9	144	0
	D3537-3	1	10	0
	D3672-1	2	1,439	0
270-Handfinish - 4-2-Assembly-B4B	D4956-15	1	7	0
	D4956-23	1	16	0
	D4956-35	1	21	0
	D4956-39	1	9	0
	NAS1149C0332R	80	2,920	0
	NAS1149C0463R	1	205	0
Part Specifications				
Specifications could not be found.				

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Qty	QTY	Part Number	Description
1	1	D874-041	SHOOTTUBE ASSEMBLY
1	1	D874-042	SHOOTTUBE ASSEMBLY
1	1	D874-043	SHOOTTUBE ASSEMBLY (FOR PFI)
1	1	D874-044	SHOOTTUBE ASSEMBLY
1	1	D874-045	SHOOTTUBE ASSEMBLY
1	1	D874-046	SHOOTTUBE ASSEMBLY
1	1	D874-047	SHOOTTUBE ASSEMBLY
1	1	D874-048	SHOOTTUBE ASSEMBLY
1	1	D874-049	SHOOTTUBE ASSEMBLY
1	1	D874-050	SHOOTTUBE ASSEMBLY
1	1	D874-051	SHOOTTUBE ASSEMBLY
1	1	D874-052	SHOOTTUBE ASSEMBLY
1	1	D874-053	SHOOTTUBE ASSEMBLY
1	1	D874-054	SHOOTTUBE ASSEMBLY
1	1	D874-055	SHOOTTUBE ASSEMBLY
1	1	D874-056	SHOOTTUBE ASSEMBLY
1	1	D874-057	SHOOTTUBE ASSEMBLY
1	1	D874-058	SHOOTTUBE ASSEMBLY
1	1	D874-059	SHOOTTUBE ASSEMBLY
1	1	D874-060	SHOOTTUBE ASSEMBLY
1	1	D874-061	SHOOTTUBE ASSEMBLY
1	1	D874-062	SHOOTTUBE ASSEMBLY
1	1	D874-063	SHOOTTUBE ASSEMBLY
1	1	D874-064	SHOOTTUBE ASSEMBLY
1	1	D874-065	SHOOTTUBE ASSEMBLY
1	1	D874-066	SHOOTTUBE ASSEMBLY
1	1	D874-067	SHOOTTUBE ASSEMBLY
1	1	D874-068	SHOOTTUBE ASSEMBLY
1	1	D874-069	SHOOTTUBE ASSEMBLY
1	1	D874-070	SHOOTTUBE ASSEMBLY
1	1	D874-071	SHOOTTUBE ASSEMBLY
1	1	D874-072	SHOOTTUBE ASSEMBLY
1	1	D874-073	SHOOTTUBE ASSEMBLY
1	1	D874-074	SHOOTTUBE ASSEMBLY
1	1	D874-075	SHOOTTUBE ASSEMBLY
1	1	D874-076	SHOOTTUBE ASSEMBLY
1	1	D874-077	SHOOTTUBE ASSEMBLY
1	1	D874-078	SHOOTTUBE ASSEMBLY
1	1	D874-079	SHOOTTUBE ASSEMBLY
1	1	D874-080	SHOOTTUBE ASSEMBLY
1	1	D874-081	SHOOTTUBE ASSEMBLY
1	1	D874-082	SHOOTTUBE ASSEMBLY
1	1	D874-083	SHOOTTUBE ASSEMBLY
1	1	D874-084	SHOOTTUBE ASSEMBLY
1	1	D874-085	SHOOTTUBE ASSEMBLY
1	1	D874-086	SHOOTTUBE ASSEMBLY
1	1	D874-087	SHOOTTUBE ASSEMBLY
1	1	D874-088	SHOOTTUBE ASSEMBLY
1	1	D874-089	SHOOTTUBE ASSEMBLY
1	1	D874-090	SHOOTTUBE ASSEMBLY
1	1	D874-091	SHOOTTUBE ASSEMBLY
1	1	D874-092	SHOOTTUBE ASSEMBLY
1	1	D874-093	SHOOTTUBE ASSEMBLY
1	1	D874-094	SHOOTTUBE ASSEMBLY
1	1	D874-095	SHOOTTUBE ASSEMBLY
1	1	D874-096	SHOOTTUBE ASSEMBLY
1	1	D874-097	SHOOTTUBE ASSEMBLY
1	1	D874-098	SHOOTTUBE ASSEMBLY
1	1	D874-099	SHOOTTUBE ASSEMBLY
1	1	D874-100	SHOOTTUBE ASSEMBLY

GENERAL NOTES:

1. MATERIAL: N/A
2. FINISH: N/A
3. ON-041: N/A
4. ON-042: N/A
5. ON-043: N/A
6. ON-044: N/A
7. ON-045: N/A
8. ON-046: N/A
9. ON-047: N/A
10. ON-048: N/A
11. ON-049: N/A
12. ON-050: N/A
13. ON-051: N/A
14. ON-052: N/A
15. ON-053: N/A
16. ON-054: N/A
17. ON-055: N/A
18. ON-056: N/A
19. ON-057: N/A
20. ON-058: N/A
21. ON-059: N/A
22. ON-060: N/A
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24. ON-062: N/A
25. ON-063: N/A
26. ON-064: N/A
27. ON-065: N/A
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29. ON-067: N/A
30. ON-068: N/A
31. ON-069: N/A
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40. ON-078: N/A
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42. ON-080: N/A
43. ON-081: N/A
44. ON-082: N/A
45. ON-083: N/A
46. ON-084: N/A
47. ON-085: N/A
48. ON-086: N/A
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52. ON-090: N/A
53. ON-091: N/A
54. ON-092: N/A
55. ON-093: N/A
56. ON-094: N/A
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58. ON-096: N/A
59. ON-097: N/A
60. ON-098: N/A
61. ON-099: N/A
62. ON-100: N/A

RELEASED
R 2015-07-26
Ecu/11-616

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19-09-19

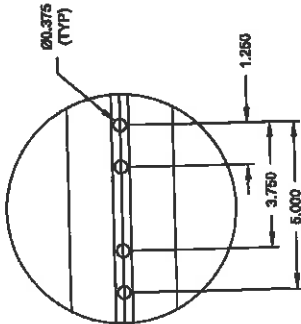
REV.	DESCRIPTION	DATE
G	ADD -045 CONFIGURATION (FOR PFI) ZN A5-4, A5-8 REVISE NOTE 2, 7 & 12, ADD NOTE 14 (ZN A5-1)	DS 18.04.25
F	REVISE NOTE 2: ADD ANTI-SKID PAINT, REMOVE GASKETS PER IN-D208-042 REV Q	DB 14.04.15
E	REVISE NOTE 2: FINISH NON PRIMER/PAINT	DW 13.05.17
D	WAS POWDERCOAT, REF: PAR13-256	CP 08.12.19
C	NEW INSERTS, 68 WEARSHOE + GASKET	CP 05.03.18
B	ADD -043, NEW INSERTS	CP 04.08.09
A	MOVE SADDLE HOLE: 42.14 WAS 42.76	CP 04.03.15
	NEW ISSUE	BY DATE
DESIGN	CP RF	
DRAWN	AK	
CHECKED	AK	
MFG. APPR	JLM	
APPROVED	DS	
DE APPR.	DS	
DATE	16.04.25	

DART AEROSPACE USA, INC
EUGENE, OR

REV. G
DRAWING NO. D3274
SHEET 1 OF 3
SCALE
TITLE SKIOTUBE ASSEMBLY
NTS
DATE 16.04.25
COMPONENT 8 DART AEROSPACE USA, INC
THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE USA, INC. IT IS TO BE USED FOR THE PURPOSES SPECIFIED ONLY. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.

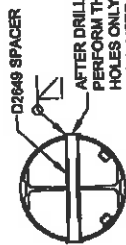
DATE 16.04.25

DETAIL A: DRILL DETAIL
D3-2, D3-4, D3-5, D3-3



DETAIL B
D3-4, D3-3

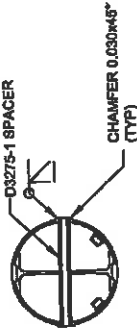
FOR 0.00375 HOLES ONLY



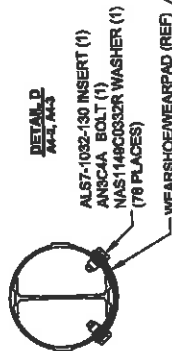
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.00375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE TO 0.00313x0.75 DEEP

DETAIL C
D3-2, D3-3

FOR 0.00313 HOLES ONLY



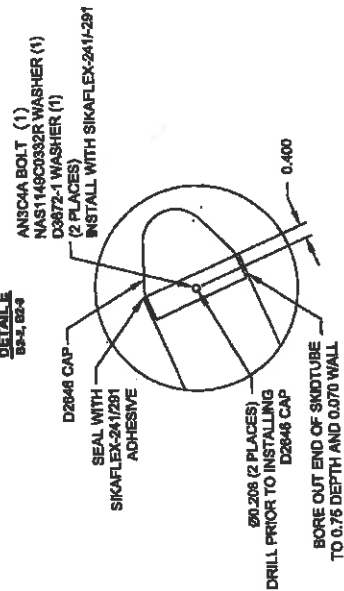
DETAIL D
A3-2, A3-3



DETAIL F: END FINISHING DETAIL
B7-2, B7-3



DETAIL E
B3-4, B3-3



DETAIL F NOTES
1. CONTINUE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART Q31 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

DESIGN	CP	RF	AK	JLM	D8	DATE	16.04.25	1
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DESIGN	CP	RF	AK	JLM	D8	DATE	16.04.25</
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Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only

NCR No. _____

DEPARTMENT/PROCESS

DISPOSITION

Job: _____
Part No. _____

Rework ☐
Scrap ☐
Use-as-is ☐

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

MRB (Q51042)

QTY Affected :

Sequence #:

Disposition

Description Work Order Deviation

Completed By

Lead hand / Supervisor

QC / QA Coordinator

FAULT CATEGORY

Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐

Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐

Other/Details:

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐